

Work Order ID 75975

75975

Page 1

November-02-11 10:48:15 AM

Item ID: D3298-007 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Assembly
 Start Date: 02/11/2011 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 16/11/2011 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/02 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3298	Rev <u>A2 B</u> <u>AA 11.11.02</u>								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Bend tube as per template D3298-007T1 & Dwg D3298Flare end as per Dwg D3298. Ensure that sleeves and coupling are installed first								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>ST 195</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

Sp 11/11/20

(4)

M 11-11-28 (4)

(4) Sp 11-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75975

75975

Page 2

November-02-11 10:48:15 AM

Item ID: D3298-007

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tube Assembly

Start Date: 02/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

11/11/28
ME
11-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:48:18 AM

Page 1

Work Order ID: 75975

75975

Parent Item: D3298-007

D3298-007

Parent Item Name: Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-6D		Purchased	No			100	Each	34.0000	2	8			

AN818-6D

Nut

**

11/11/20

Location

Loc Qty

Loc Code

ST325

20

119438

20

ST330

14

114988

4

119083

10

M6061T6T0.375W.035

Purchased

No

100

f

216.3642

0.6666

2.806737

M6061T6T0 375W 0.35

6061-T6 RD Tube .375 x.035W

**

11/11/20

Location

Loc Qty

Loc Code

MAT014

216.3642

104913

31.75

112652

184.6142

MS20819-6D

Purchased

No

100

Each

12.0000

2

8

MS20819-6D

Sleeve

**

11/11/20

Location

Loc Qty

Loc Code

ST323

12

116289

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

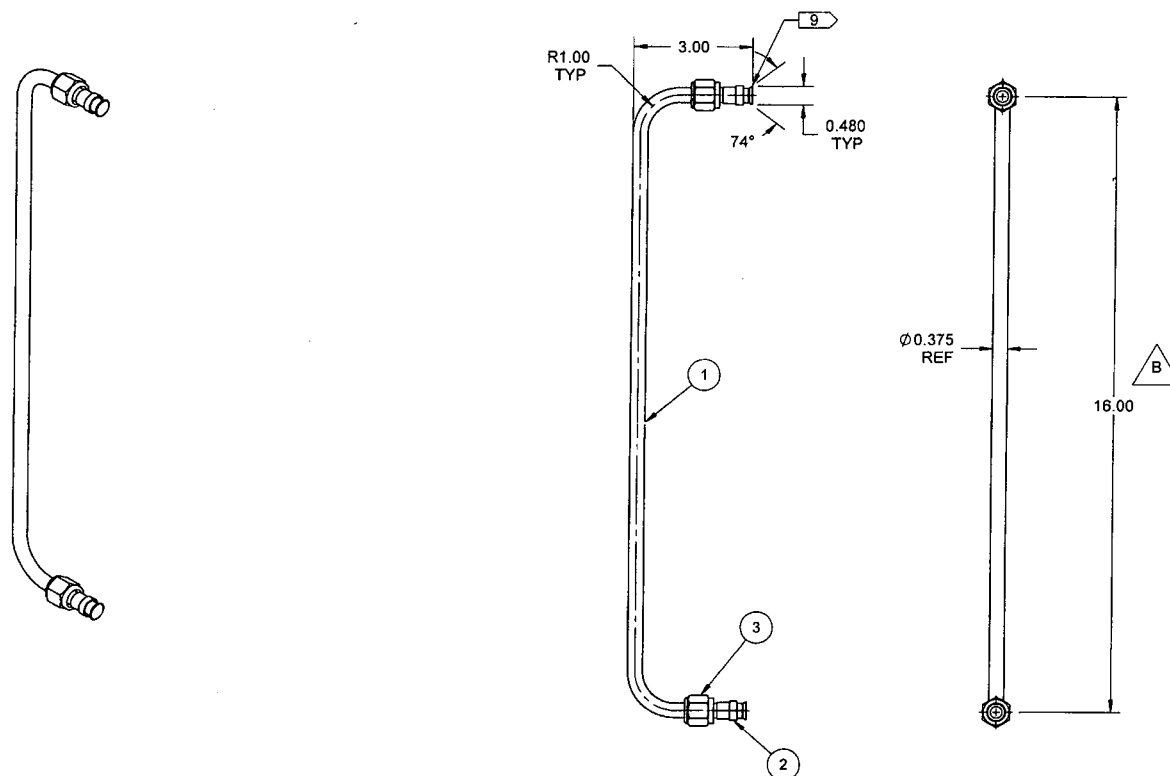
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY -001	P/N	DESCRIPTION
1	X	D3298-001	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-001 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
[Signature]

B	DRAWING UPDATED TO CURRENT STANDARDS. 16.00 WAS 15.75 (ZN C3-1, C4-2) & CORRECT VIEW (ZN D4-2). PER CAR 09-004	RF	09.12.30
A	NEW ISSUE	RF	04.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3298 TITLE TUBE ASSEMBLIES COPYRIGHT © 2004 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.12.30	REV. B SHEET 1 OF 8 SCALE NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

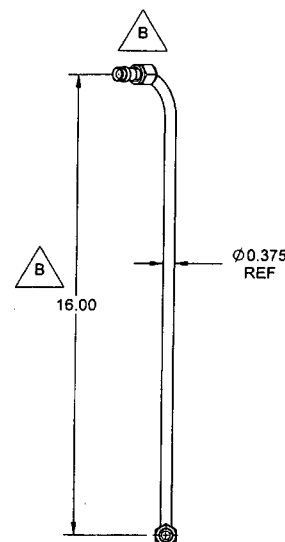
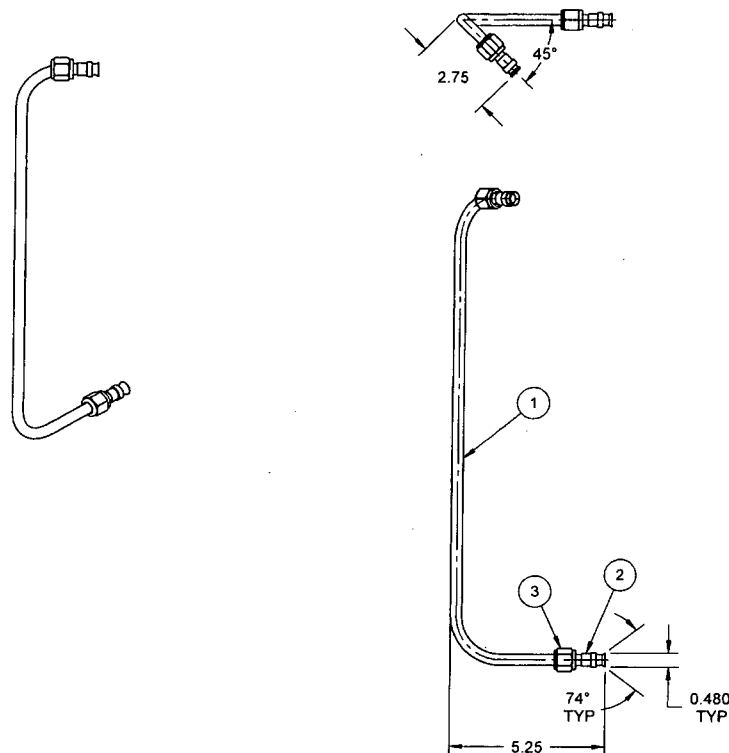
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -003	P/N	DESCRIPTION
1	X	D3298-003	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-003 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-003" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-003T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10 ENSURE SEAMLESS TUBING IS USED

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2010-01-14

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DE APPR.	RF	TUBE ASSEMBLIES	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

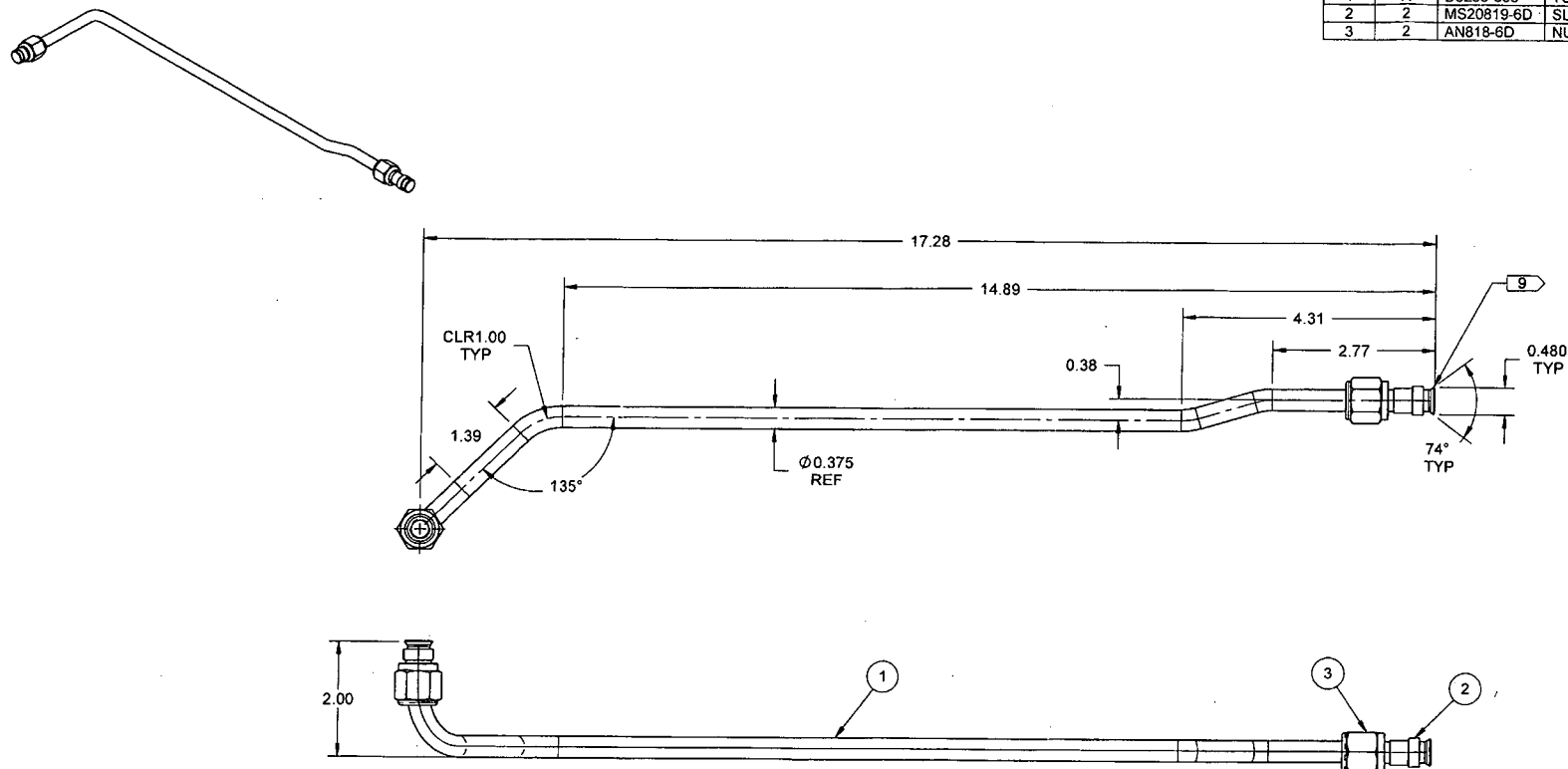
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -005	P/N	DESCRIPTION
1	X	D3298-005	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-005 TUBE ASSEMBLY

RELEASED
2010-01-14
MB

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-005" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-005T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

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DE APPR.	40	TUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

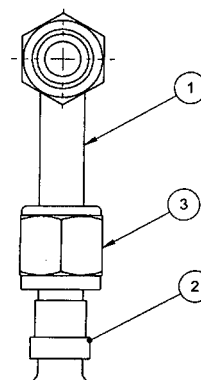
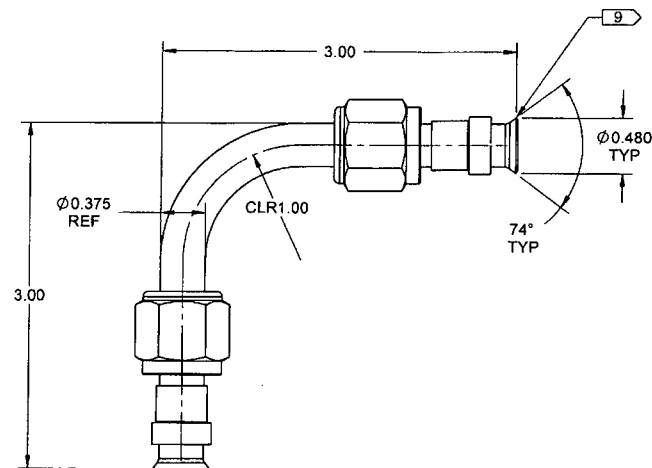
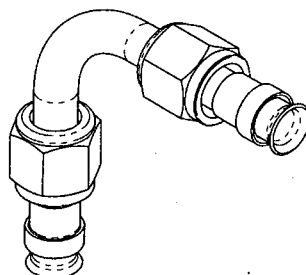
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -007	P/N	DESCRIPTION
1	X	D3298-007	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-007 TUBE ASSEMBLY

RELEASED
2010-01-14

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-007" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-007T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10 ENSURE SEAMLESS TUBING IS USED

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MFG. APPR.	RF		SHEET 4 OF 8
APPROVED	RF	TITLE TUBE ASSEMBLIES	SCALE NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

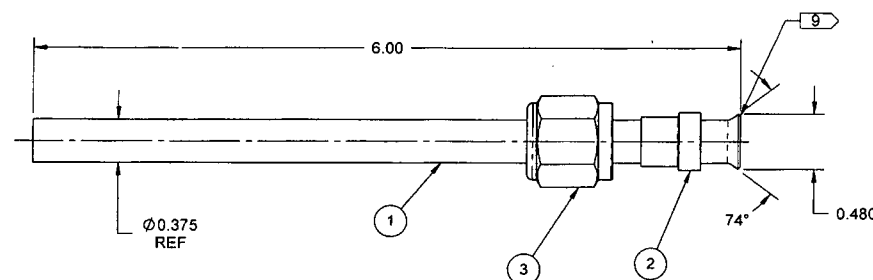
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -009	P/N	DESCRIPTION
1	X	D3298-009	TUBE ASSEMBLY
2	1	MS20819-6D	SLEEVE
3	1	AN818-6D	NUT



D3298-009 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3298	SHEET 5 OF 8
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DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLIES	NTS
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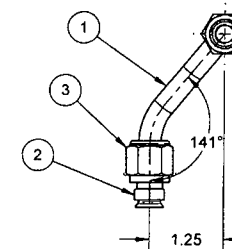
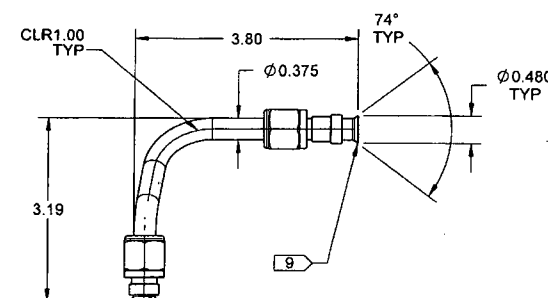
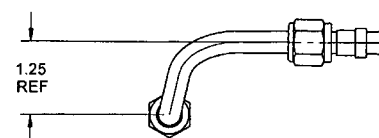
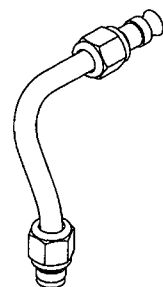
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	P/N	DESCRIPTION
1	X	D3298-011	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-011 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-011" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-011T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10 ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
[Signature]

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>ES</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>ES</i>	D3298	SHEET 6 OF 8
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	TUBE ASSEMBLIES	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

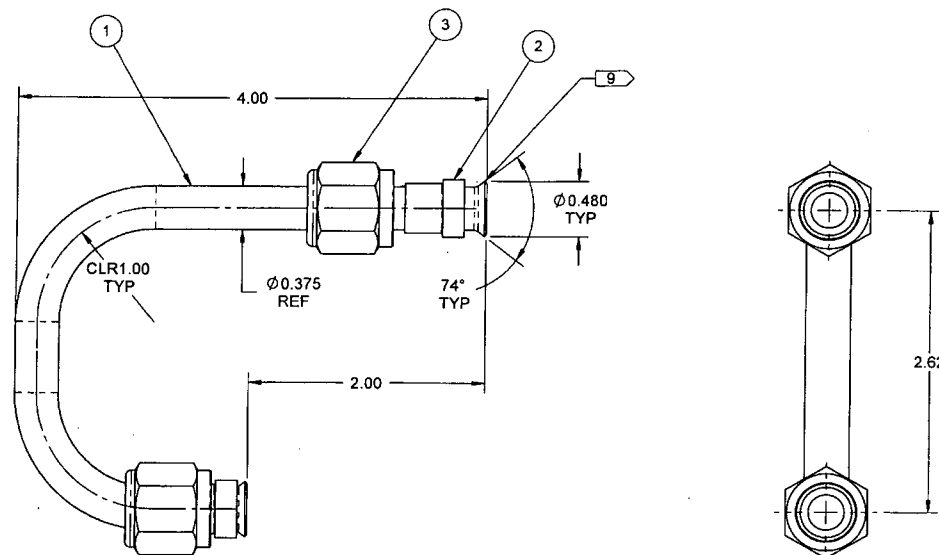
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -013	P/N	DESCRIPTION
1	X	D3298-013	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-013 TUBE ASSEMBLY

RELEASED
2010-01-14

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER VW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-013" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-013T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3298	REV. B
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	TUBE ASSEMBLIES	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

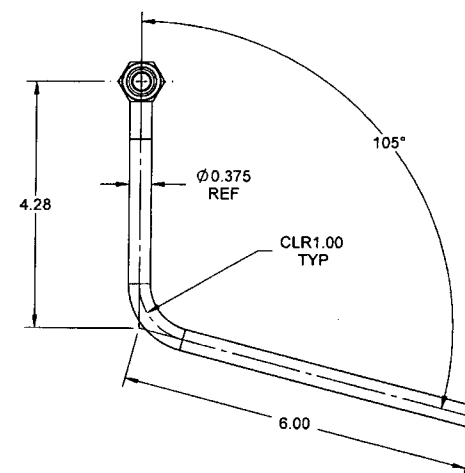
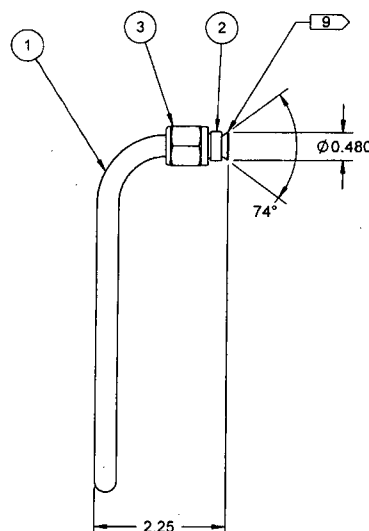
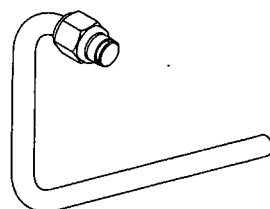
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -015	P/N	DESCRIPTION
1	X	D3298-015	TUBE ASSEMBLY
2	1	MS20819-6D	SLEEVE
3	1	AN818-6D	NUT



D3298-015 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-015" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-015T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10 ENSURE SEAMLESS TUBING IS USED

RELEASED
2018-01-14
JAD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3298	REV. B
MFG. APPR.	RF	TITLE TUBE ASSEMBLIES	SHEET 8 OF 8
APPROVED	RF	SCALE NTS	
DE APPR.	RF	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	09.12.30		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries